

Work Order ID 56109

Page 1

February 10, 2010 12:18:29 PM

Item ID: D3561-1

Accept



Setup Start



Revision ID:

Item Name: Seal Insert Tool

Stop



Start Date: 2/10/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

11

Date: 10-2-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3561

Rev A

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3561 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

R 10-2-17

11

100

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

Quality Control

R 10-2-12

110

QC8- Inspect parts - second check

0.00



Memo

0.00

Quality Control

S 10-2-16

R 10-2-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

EF 10/03/03 10

Small Fab

Memo

0.00

Deburr if necessary.

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3561

SB 10/03/03

150



QC5- Inspect part completeness to step on W/O

0.00

SW 10/03/03

QC

Memo

0.00

(4W)

Quality Control

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Identify as per dwg & Stock Location:

70

0.00

10-3-3

CPT

Packaging

Memo

0.00

170



QC21- Final Inspection - Work Order Release

0.00

10/03/03 KJ

QC

Memo

0.00

ME 10-3-3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

February 10, 2010 12:18:32 PM

Work Order ID: 56109



Parent Item: D3561-1



Parent Item Name: Seal Insert Tool

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP: A 06.10.19 New issue ECO

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased		No		100	sf	81.7878	0.3983	6 	B 10-2-12	

304/316 0.125 Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	81.7878
112663	81.7878

(1)

112663

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DART AEROSPACE LTD	Work Order:	56109
Description: Seal Insert Tool	Part Number:	D3561-1
Inspection Dwg: D3561 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>RB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-2-12	Date:	10/02/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EZ

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO

DART

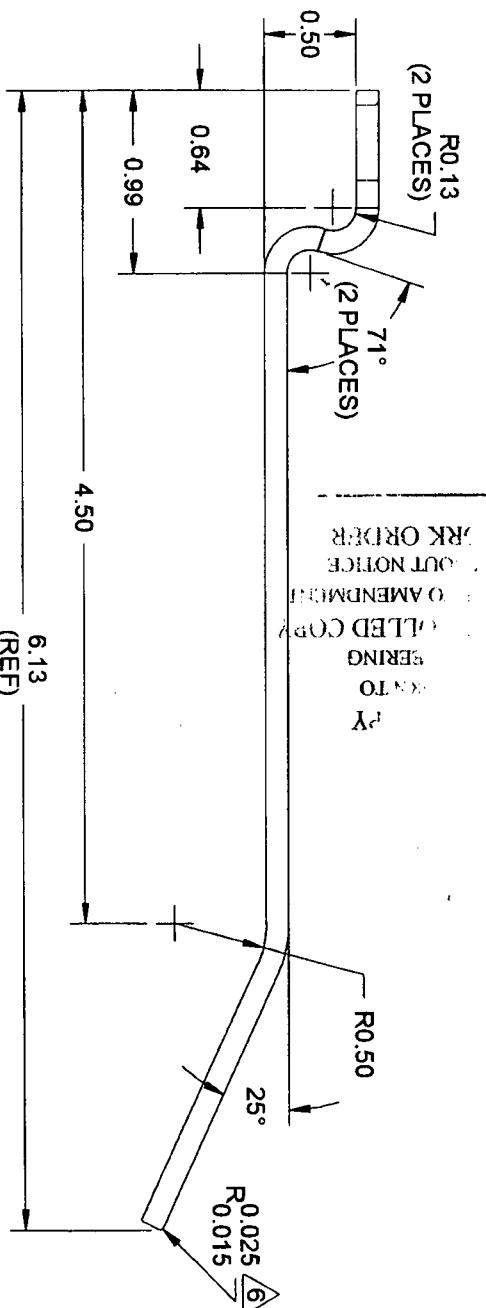
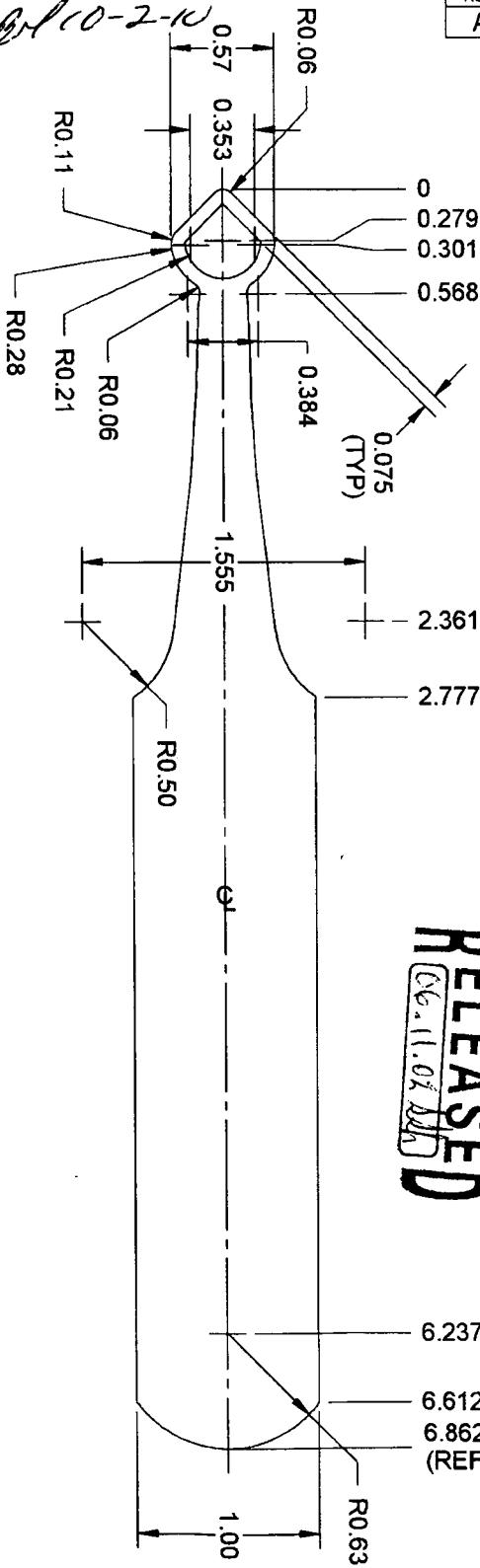
WITHOUT

WORK CREDITS

NO. 5C4109

PRL10-2-10

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JW</i>	DRAWING NO.	REV. A
DATE 06.10.06		TITLE	SHEET 1 OF 1
		SEAL INSERT TOOL	SCALE 1:1
REV. A	DATE 06.10.06	DESCRIPTION NEW ISSUE	



D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025

RELEASED
(06-11-06)

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